

Date: Wednesday, 1/11/2006 4:30:08 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEBBING TIDY
 Job Number : 25479
 Estimate Number : 11381
 P.O. Number : N/A Part Number : D32153
 This Issue : 1/11/2006 S.O. No. : N/A Drawing Number : D3215 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C
 Previous Run : N/A Material : N/A
 Written By : SPE COMMENT REW Due Date : 1/31/2006 Qty: 190 Um: Each
 Checked & Approved By : Kim Johnston
 Comment : Est. A04.01.06. New issue KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0271 sf(s)/Unit Total: 5.1471 sf(s)
 5052-H32 .040 Sheet
 Material: 5052-H32 (QQ-A-250/8) 0.040" thick
 (M5052H32S.040)
 Identify for D3215-3A
 Batch: M15982

En 06/01/27

2.0 SHEAR SHEAR



Comment: SHEAR

along 2.562"

En 06/01/27 x 200

3.0 HAAS CNC VERTICAL MACHINING #1

Ship to
Tulmar
do not
stock



Cor MACHINING #1
 FA376 and dimensions

x200

J.F. / BG 06/01/28

4.0 INSPECT PARTS AS THEY COME OFF MACHINE



Cc COME OFF MACHINE

J.F. / BG 06/01/28

5.0 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 Deburr

J.F. / BG 06/01/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:30:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 25479

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BG 06.01.28 200

7.0

M5052H32S040

5052-H32 .040 Sheet



Comment: Qty.: 0.0271 sf(s)/Unit Total: 5.1471 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S.040)

Identify as D3215-3B

Batch: M17400

8.0

SHEAR

SHEAR



Comment: SHEAR

Cut blank: 2.130" x 0.530"

Deburr D3215-3A/-3B

BG 06.01.28 200

9.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

SB 06/01/31 203

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/01/31

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

Identify as D3215-3

Grind flush

SB 06/02/09 207
PTD

CPL 06.02.06

12.0

QC5/9

WELD INSPECTION

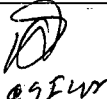
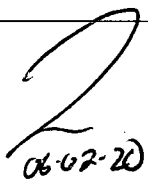

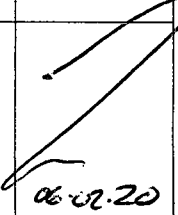


Comment: WELD INSPECTION

06/02/09 207

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/02/09	1	1 was scrap	 06/02/09	Scrap & destroy	SP. 06/02/09	 06-02-20	 06-02-20	 06-02-20

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:30:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 25479

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 06 02 16

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-02-17

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06 02 17

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FD + STK

C 206/02/17 207

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Sur 06/02/20

(207)

19 06/02/20

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25479
Description: Webbing Tidy	Part Number:	D3215-3
Inspection Dwg: D3215 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

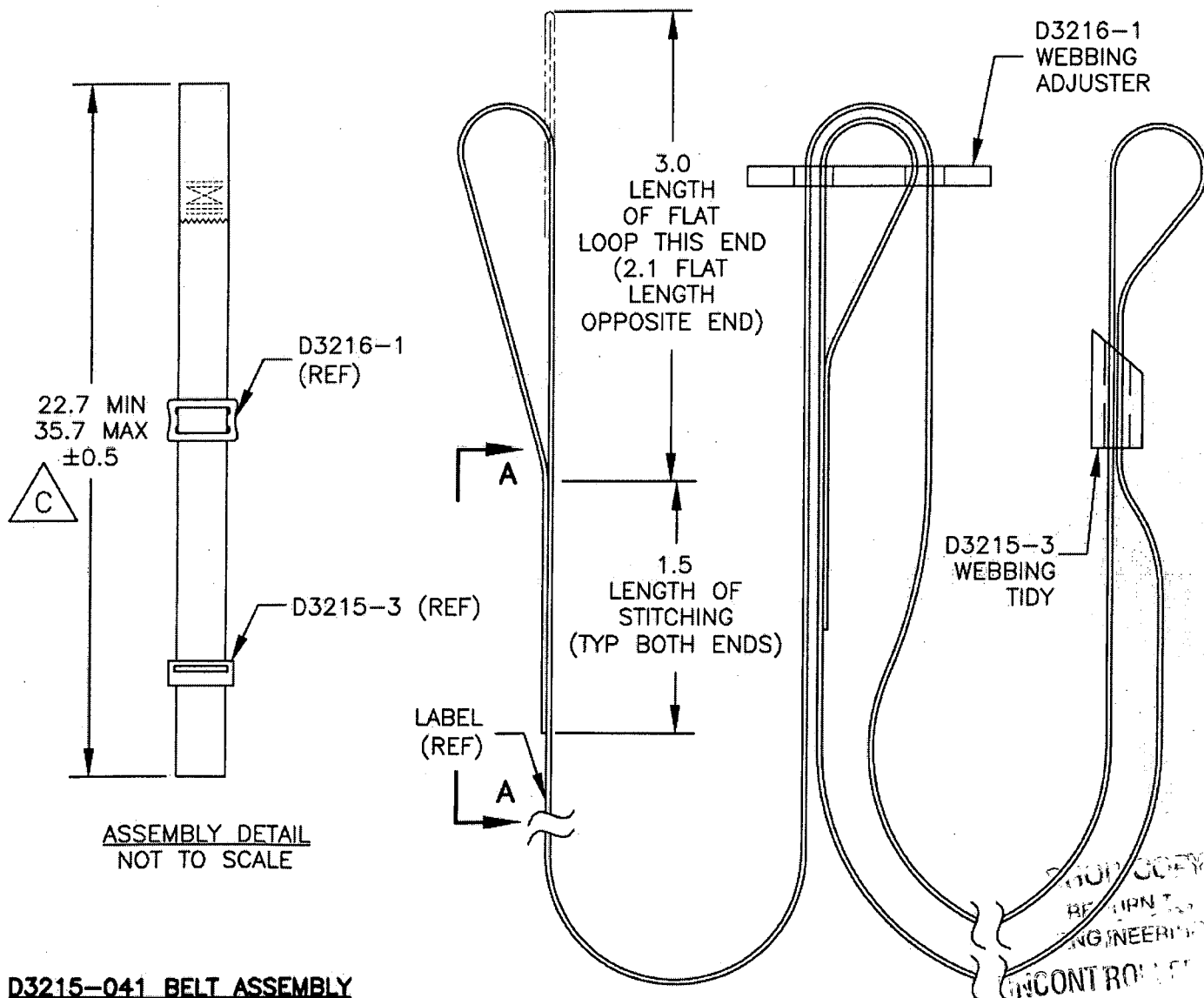
Measured by:	J-F.	Audited by:	SA	Prototype Approval:	N/A
Date:	28/01/06	Date:	06.01.28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF	



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3215	REV. C SHEET 1 OF 3
DATE	04.03.05			TITLE BELT ASSEMBLY	SCALE NTS
A	03.09.19			NEW ISSUE	
B	04.01.12			AS MANUFACTURED; ADD TOLERANCE	
C	04.03.05			REDUCE LENGTH; CLARIFY STITCHING	

RELEASED
04.03.08



D3215-041 BELT ASSEMBLY

- MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL = TYVEK
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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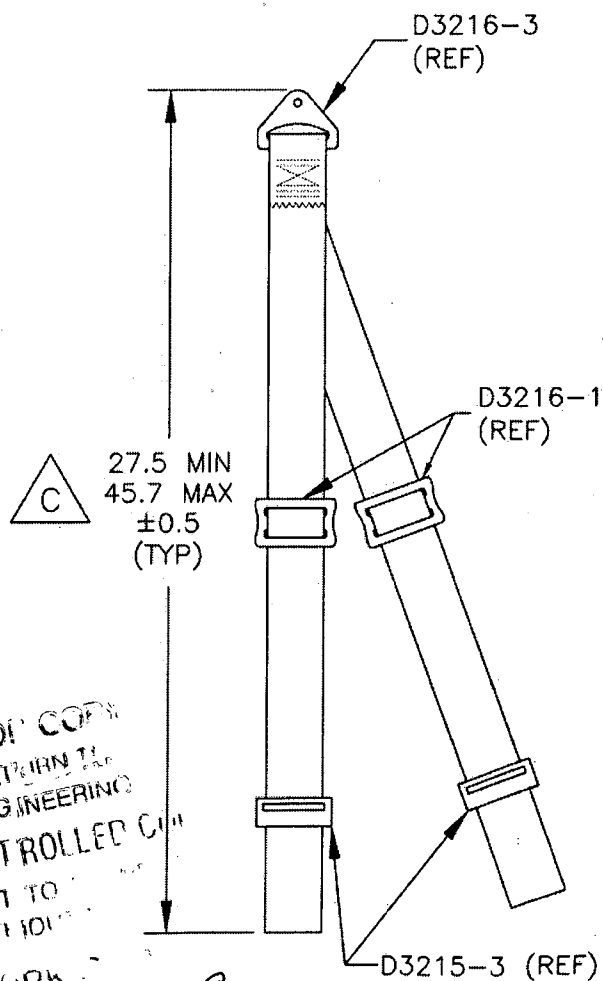
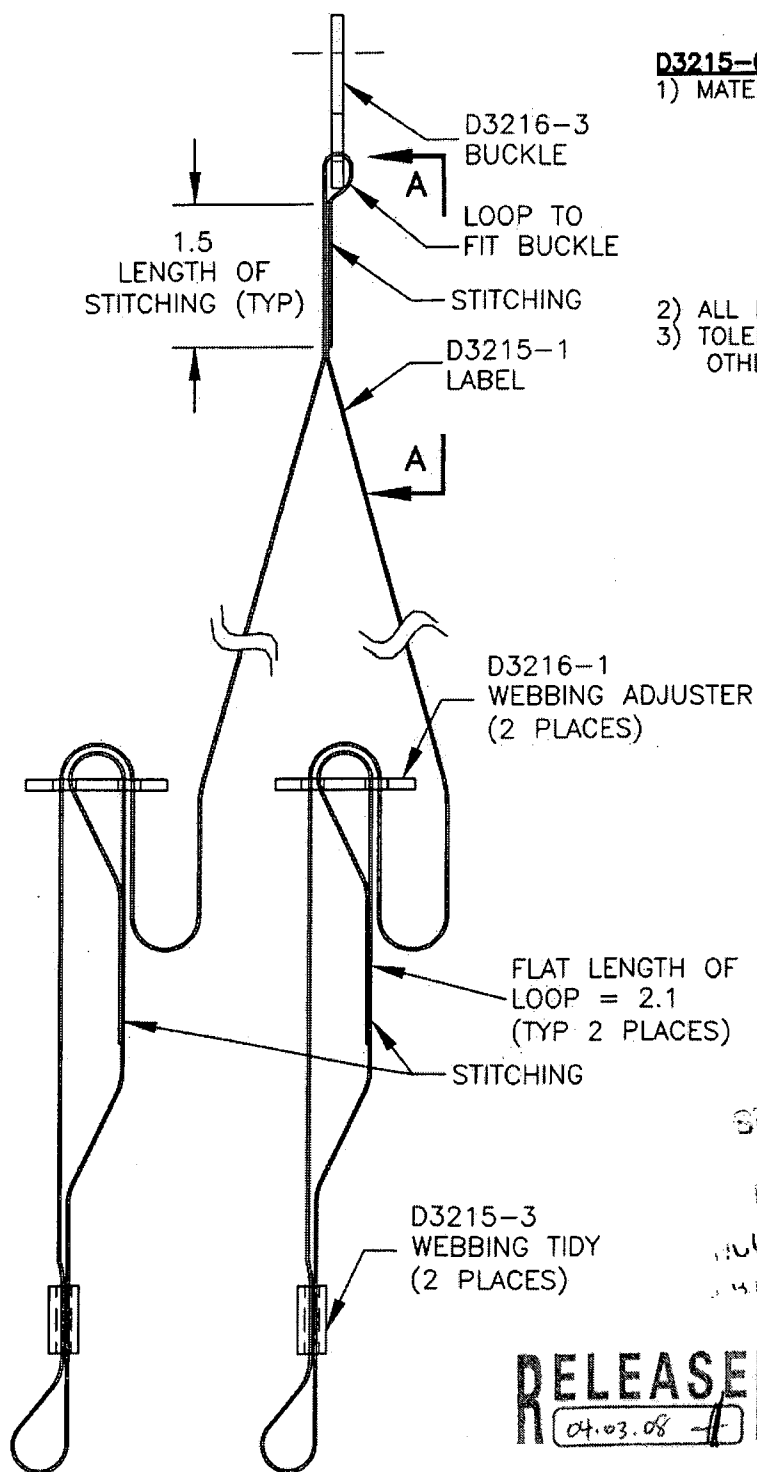
NO 25479



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3215	REV. C SHEET 2 OF 3
DATE 04.03.05		TITLE BELT ASSEMBLY	SCALE NTS

D3215-043 BELT ASSEMBLY

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK
BLACK POLYESTER WEBBING,
CERTIFIED TO FAR 29.853A3,
TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3,
BLACK NYLON THREAD
LABEL = TYVEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED.



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25479

ASSEMBLY DETAIL
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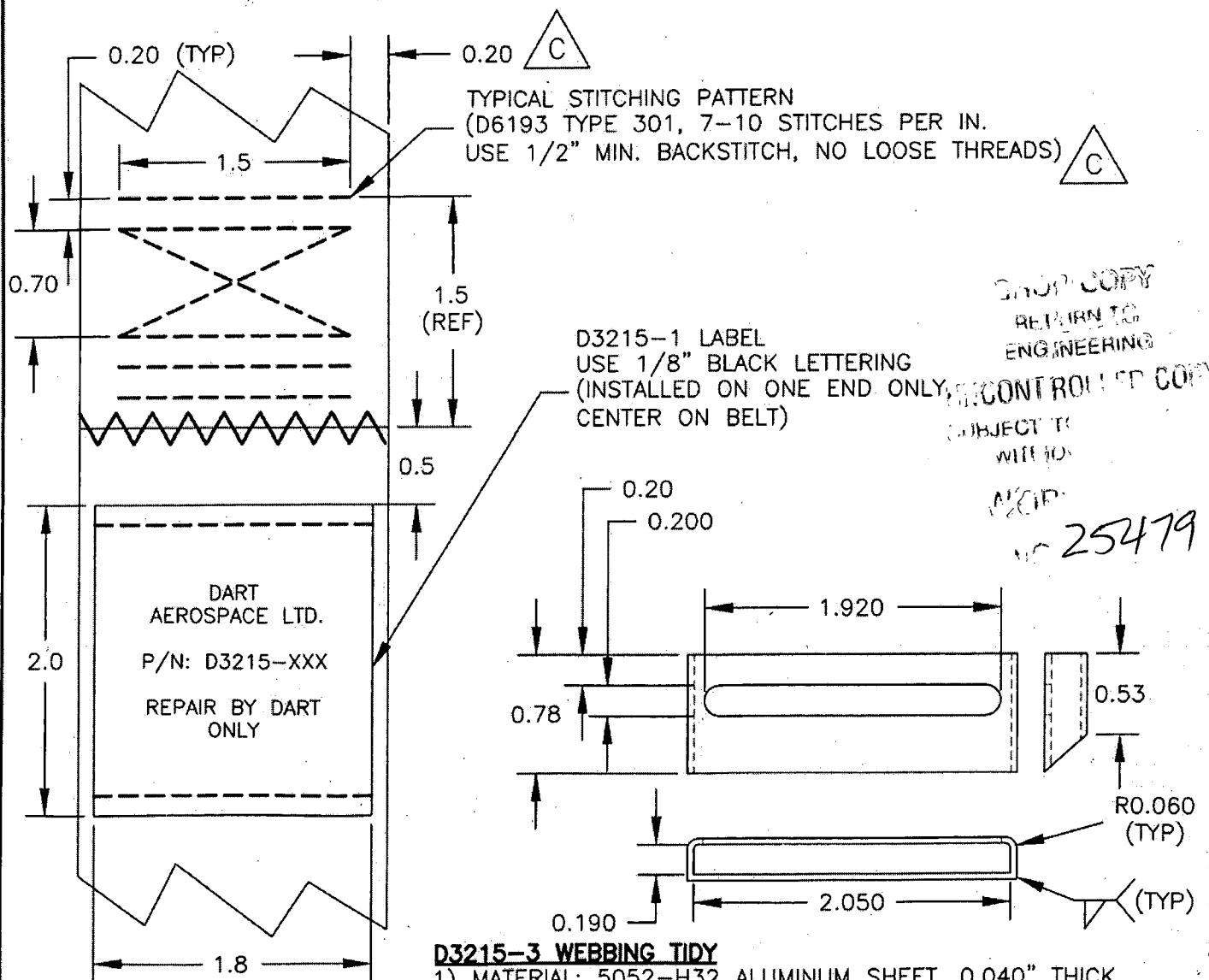
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JP</i>	APPROVED <i>JP</i>	DRAWING NO. D3215	REV. C SHEET 3 OF 3
DATE 04.03.05		TITLE HARNESS ASSEMBLY	SCALE 1:1

VIEW A-A

XXX = 041 FOR D3215-041
XXX = 043 FOR D3215-043



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25479

D3215-3 WEBBING TIDY

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040" THICK
(REF DART SPEC. M5052H32S.040)
- 2) WELD PER DART QSI 004
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED

RELEASED
04.03.08

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